

Date: Friday, 23/01/2009 11:19:34 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: NUT PLATE ASSEMBLY
Job Number	: 45210		
Estimate Number	: 11054		
P.O. Number	:	Part Number	: D2873045
This Issue	: 23/01/2009 S.O. No. :	Drawing Number	: D2873 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 44038	Material	:
Written By	:	Due Date	: 30/01/2009 Qty: 20 Um: Each
Checked & Approved By	: <u>JUL 09.01.23</u>		
Comment	: Est A05.09.13 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0375X01000	6061T6 BAR .375 x 1.00
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Comment: Qty.: 0.2363 f(s)/Unit Total : 4.7250 f(s)

6061T6 BAR

Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8) ,

(M6061T6B0.375x01.000)

Identify for D2873-5

Batch: M110001

JUL 09/01/27

(20)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks: 1.000" x 0.375" x 2.700" long

JUL 09/01/27

(20)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA and Dwg D2873

Identify as D2873-5 Dwg Rev A Folio Rev AA

(20)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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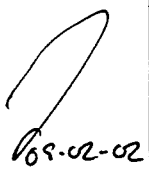

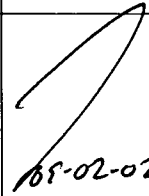

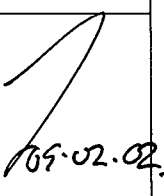
Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MUE 09/02/01

(20)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D2873-045 PAR #: N/A Fault Category: Prod/Machinal fails NCR: (Yes) No DQA: D Date: 05/03/03
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 05/03/03

NCR: <u>45210</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/02/01	3.0	Part jump out of die when machining R.C: Process.		scrap and replace Qty 1 batch M110001	09/02/01 mmw			
09/02/01	3.0	Hole are off center because Y axis was not retaken after remachining of jaws R.C: operator error.		scrap and replace Qty 1 batch M110001	mmw 09/02/01			

NOTE: Date & initial all entries

Date: Friday, 23/01/2009 11:19:35 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 45210

Part Number: D2873045

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



(20)

Comment: SECOND CHECK

H.A 09/02/01

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2- C'sink as per Dwg D2873

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/02/03 (20)
Sordelo 3 (20)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 09/02/06 (20)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

04-02-04 (20)

10.0

MS20426AD46

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Rivet

Pick;

Qty

Part Number

Description

Batch

4

MS20426AD4-6

Rivet

M105144 SS 09/02/09 (20)

11.0

MS21075L5

Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Nut Plate

Pick;

Qty

Part Number

Description

Batch

2

MS21075L5

Nut Plate

18136x11 M110916 (27x) SS 09/02/09 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/01/2009 11:19:35 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 45210

Part Number: D2873045

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Assemble as per Dwg D2873
2-Identify as D2873-045

Ep 09/02/23 (20)
counter

13.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

09/02/23 (42)

14.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *X tube assy*

8T 09-02-25 (x20)

15.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/02/26 (4)

Job Completion



U 09-02-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45 210
Description: Radius Block		Part Number: D2873-5
Inspection Dwg: D2873	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.50	✓			
1.000	+/-0.010	1.000	✓			
0.750	+/-0.010	.748	✓			
0.250	+/-0.010	.249	✓			
1.000	+/-0.010	.999	✓			
2.000	+/-0.010	2.000	✓			
Ø0.128	+0.005/-0.001	Ø .129	✓			
0.359	+/-0.010	.360	✓			
Ø0.316	+0.006/-0.001	Ø .317	✓			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	.245	✓			
0.061	+/-0.010	.061	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø .230 x .125	✓			

Measured by: <i>mmj</i>	Audited by: H.A	Prototype Approval:	N/A
Date: 09/02/01	Date: 09/02/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-045	KJ/JLM	<i>[Signature]</i>

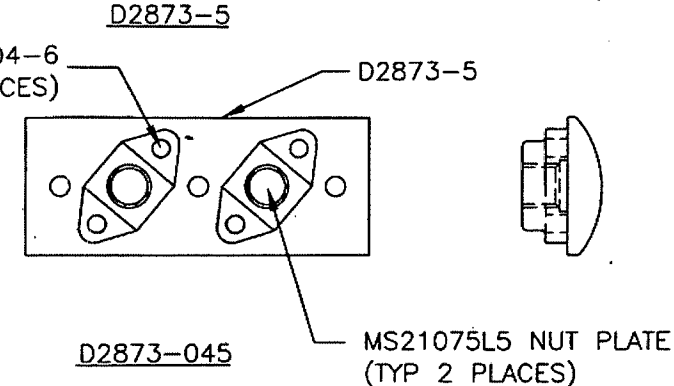
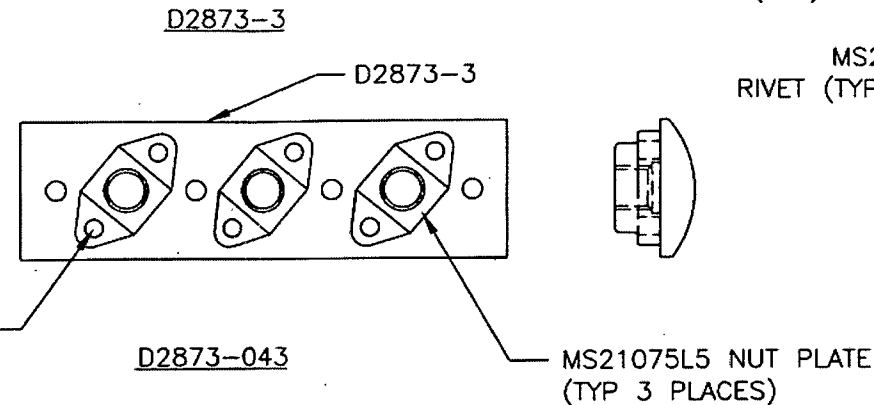
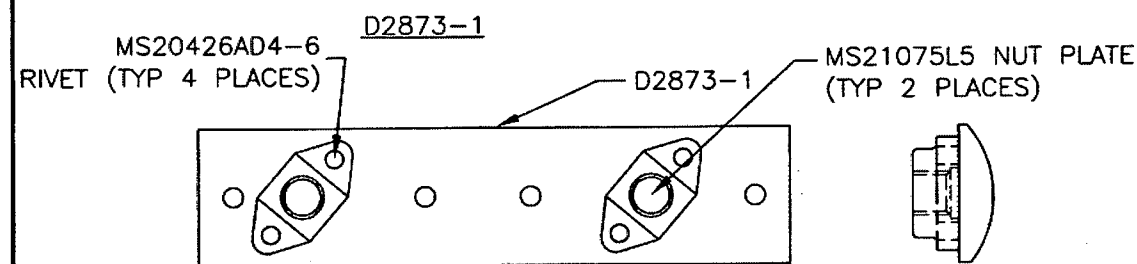
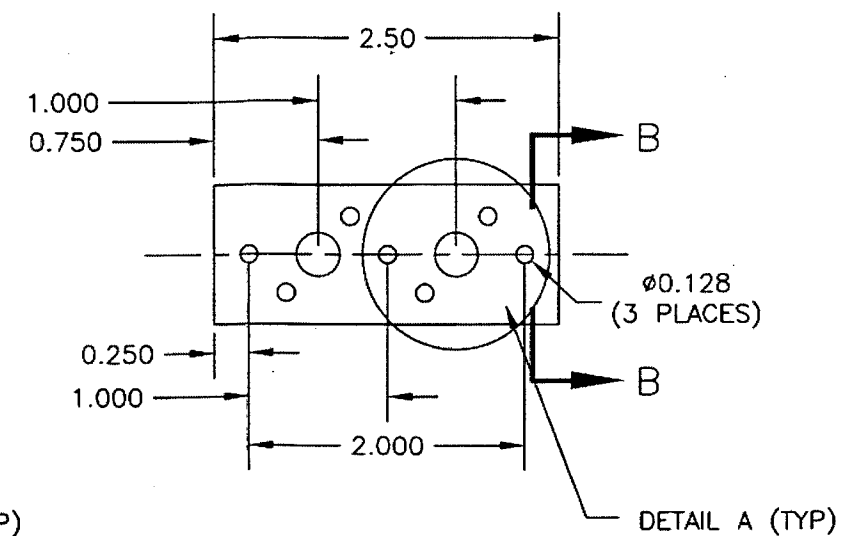
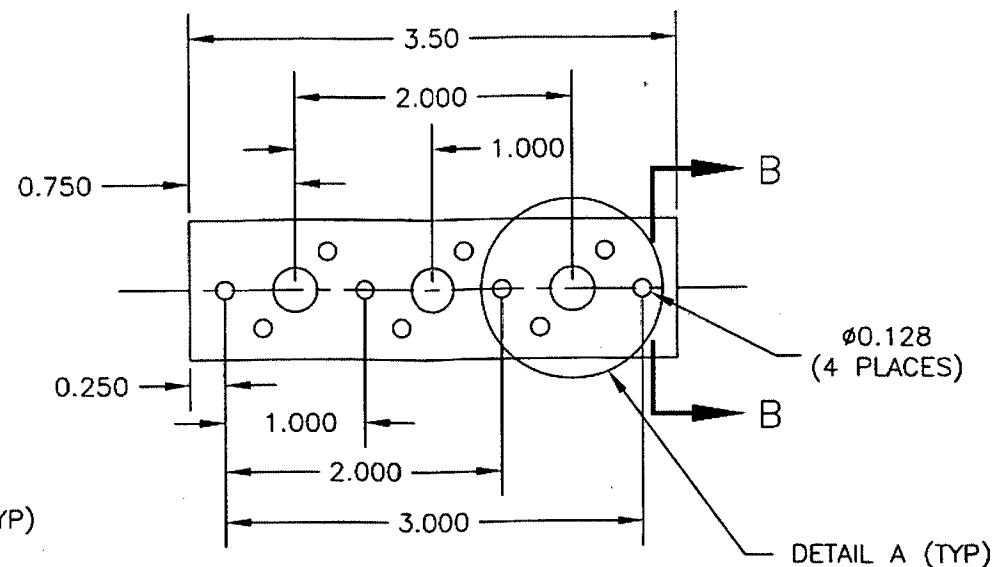
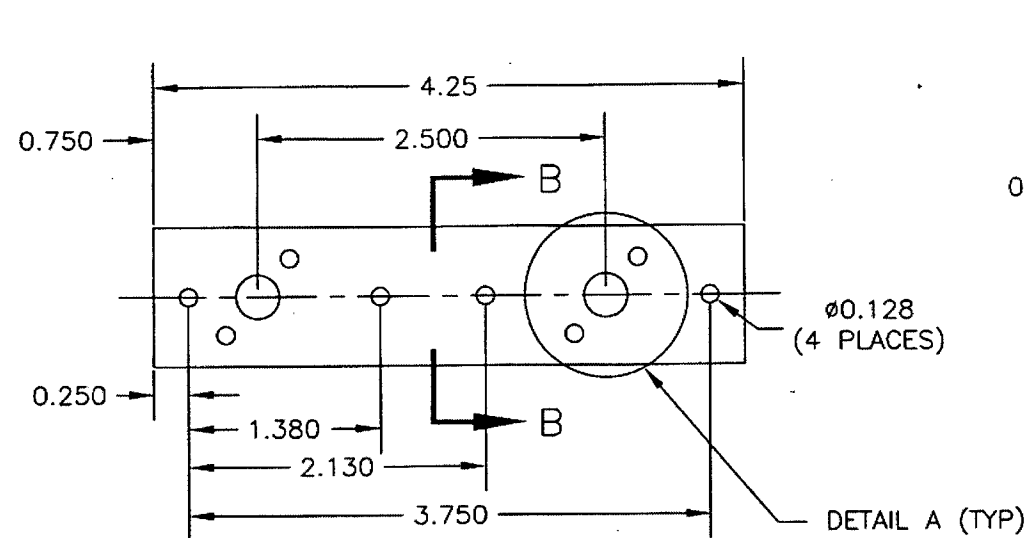
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2873-1/-3/-5 RADIUS BLOCK

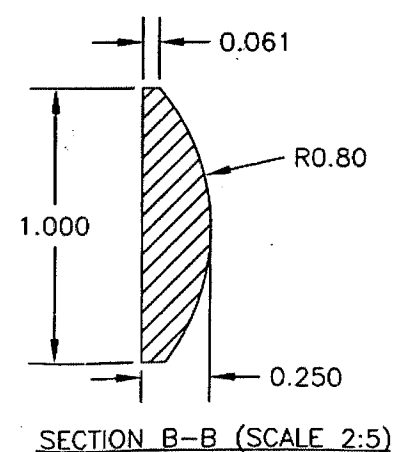
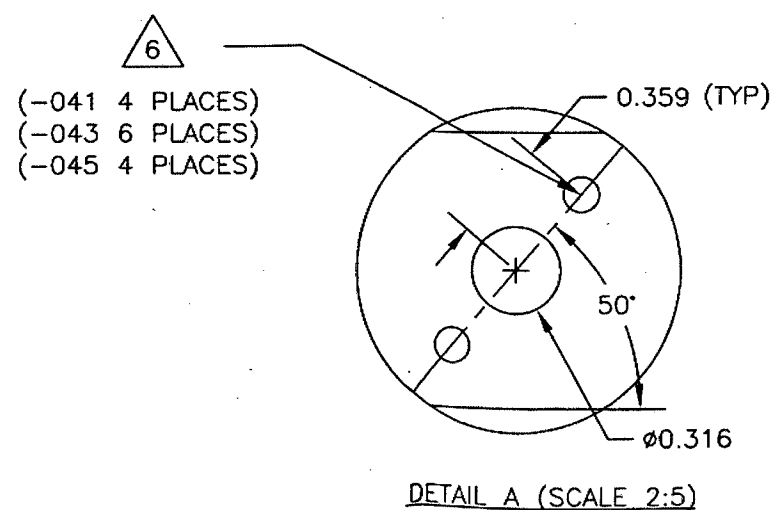
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) $\phi 0.128$ PILOT + C'BORE CURVED SIDE $\phi 0.230 \times 0.125$ DEEP + C'SINK CURVED SIDE $\phi 0.225 \times 100^\circ$

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



RELEASED
TOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4520

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>IDS</i>	APPROVED <i>IDS</i>	DRAWING NO. D2873 REV. A SHEET 1 OF 1
DATE 05.07.26	TITLE RADIUS BLOCK	SCALE 4:5